

Date: Tuesday, 5/29/2007 9:56:18 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID INSTALLATION LH,THRU BOLT
Job Number : 32707
Estimate Number : 12889
P.O. Number : N/A Part Number : D206642613
This Issue : 5/29/2007 S.O. No. : N/A Drawing Number : IIN D206-642 REV K
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : K
Previous Run : N/A Material : N/A
Written By : Due Date : 6/15/2007 Qty: 1 Um: Each
Checked & Approved By : 07.05.29
Comment : Est Rev.B Revised Pick List 05-10-27 KJ/EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-642-613

CHG002

KS 07.05.30

2.0 32707A FLOAT SKIDTUBE HIGH GEAR 206 A/B



641



Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B

D206-642-613 SUB-COMPONENT

B32707A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D206651041 206 A/B GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

206 A/B GHW Kit

Batch: B27963 ✓ ✓

5.0 D26651 Saddle, LH Fwd Aft Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Saddle, LH Fwd Aft Out

Batch: B29748 ✓ ✓

Handwritten signature and date: 07/05/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:56:19 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID INSTALLATION LH,THRU BOLT

Job Number: 32707

Part Number: D206642613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26661

Saddle, LH, Fwd,Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Saddle, LH, Fwd,Aft, In

Batch: B29668 ✓ ✓

7.0

D26671

Saddle, LH, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Saddle, LH, Aft, Out

Batch: B9064 ✓ ✓

8.0

D26681

Saddle, LH, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Saddle, LH, Aft, In

Batch: B10046 ✓ ✓

9.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Batch: M19349 - ✓

10.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Batch: B30816 ✓ ✓

11.0

MS210433

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M103286 ✓ ✓

12.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch: M101925 ✓ ✓*CP 507/05/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID INSTALLATION LH,THRU BOLT

Job Number: 32707

Part Number: D206642613

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M19185 ✓

14.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Batch: M19185 ✓

15.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Batch: M18918 ✓

16.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M101418 ✓

17.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: M19349 ✓

18.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: M101925 ✓

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch: M103344 ✓

CP 7/25/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SKID INSTALLATION LH,THRU BOLT

Job Number: 32707

Part Number: D206642613

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Batch: M103691 ✓ ✓

21.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Inventory

Batch: M101542 ✓ ✓

22.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Batch: M104537 ✓ ✓

23.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

Batch: M103964 ✓ ✓

24.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

NUT

Batch: M103693 ✓ ✓

25.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M19185 ✓ ✓

26.0

D2712

Set Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Set Screw

Batch: B31927 ✓ ✓

EP 5/29/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 32707

Part Number: D206642613

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle Spacer

Batch: B29453 ✓

28.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle Spacer

Batch: B29199 ✓

29.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Batch: M19349 ✓

30.0

AN960C10L

washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

washer

Batch: M101692 ✓

31.0

NAS1515H3L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M19565 ✓

32.0

MS210433

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

Batch: M103286 ✓

33.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Batch: B26772 ✓

EP 5/29/07/290

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 27/06/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32707

Part Number: D206642613

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Batch: 1718918 ✓

35.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Batch: 1718918 ✓

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 2071051300

10/2/07/30 (1)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-613

Location: A

PPP Rev: A

10/2/07/14

(1)

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/2/07/14 (1)

Job Completion



10/2/07/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.7 206A/B High Gear Float Skidtubes (TRI-BAG COMPATIBLE)

Item	Qty -611	Qty -612	Qty -613	Qty -614	Qty -641	Qty -645	Part Number	Description
	X						D206-642-611	SKIDTUBE INSTALLATION, LH
		X					D206-642-612	SKIDTUBE INSTALLATION, RH
			X				D206-642-613	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-614	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X		D206-642-641	SKIDTUBE
						X	D206-642-645	WEARSHOE KIT (REPLACES -643 KIT)
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER ⁽³⁾
1					1		D3288-041	SKIDTUBE ASSEMBLY
3					1		D2646	* AFT CAP ⁽¹⁾
4					2		AN3C4A	* BOLT ⁽¹⁾
5A					2		AN960C10L	* WASHER ⁽¹⁾
5B					2		NAS1515H3L	* WASHER ⁽¹⁾
6	1		1				D2665-1	SADDLE, FWD OUT, LH
6		1		1			D2665-2	SADDLE, FWD OUT, RH
7	1		1				D2666-1	SADDLE, FWD IN, LH
7		1		1			D2666-2	SADDLE, FWD IN, RH
8	1						D2665-1	SADDLE, AFT OUT, LH
8		1					D2665-2	SADDLE, AFT OUT, RH
8			1				D2667-1	SADDLE, AFT OUT, LH
8				1			D2667-2	SADDLE, AFT OUT RH
9	1						D2666-1	SADDLE, AFT IN, LH
9		1					D2666-2	SADDLE, AFT IN, RH
9			1				D2668-1	SADDLE, AFT IN, LH
9				1			D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8			AN3C41A	BOLT
11	16	16	16	16			D2652	BUSHING
12A	8	8	8	8			MS21043-3	NUT
12B	16	16	16	16			NAS1515H5	WASHER
13	4	4	4	4			AN5C7A	BOLT
14	4	4	4	4			AN5C11A	BOLT
14A	4	4	4	4			AN5C32A	* BOLT ⁽²⁾
14B	4	4	4	4			MS21043-5	* NUT ⁽²⁾
15A	8	8	8	8			AN960C516L	WASHER
15B	8	8	8	8			NAS1515H5L	WASHER
16	12	12	12	12			AN4C6A	BOLT
17A	24	24	24	24			AN960C416L	WASHER
17B	24	24	24	24			NAS1515H4L	WASHER
18	12	12	12	12			MS21043-4	NUT
20A					7	7	D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1	D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1	D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1	D3536-15	* GASKET ⁽¹⁾
23A					1	1	D3535-21	* WEARSHOE ⁽¹⁾ (REPLACES D2656-21)
23B					1	1	D3536-21	* GASKET ⁽¹⁾
24A					1	1	D3535-41	* WEARSHOE ⁽¹⁾ (REPLACES D3287-3)
24A					1	1	D3536-41	* GASKET ⁽¹⁾
25A					1	1	D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1	D3536-35	* GASKET ⁽¹⁾
26A					64	64	AN3C4A	* BOLT ⁽¹⁾
26B					64	64	AN960C10L	* WASHER ⁽¹⁾
26C					64		ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
28	2	2	2	2			AN6C44A	BOLT
29A	2	2	2	2			MS21043-6	NUT
29B	4	4	4	4			AN960C616	WASHER

continued on next page...

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Revision: K

Date: 06.09.25

continued from previous page...

Item	Qty -611	Qty -612	Qty -613	Qty -614	Qty -641	Qty -645	Part Number	Description
34					1		AN4C5A	BOLT
35					1		AN960C416	WASHER
36					1		D3413-1	RING
37	10	10	5	5			D2712	SET SCREW
38	2	2	2	2			D2884	SADDLE SPACER
39	2	2	2	2			D2885	SADDLE SPACER
50	9	9	9	9			AN3C36A	BOLT
52	18	18	18	18			AN960C10L	WASHER
53	18	18	18	18			NAS1515H3L	WASHER
54	9	9	9	9			MS21043-3	NUT
55	2	2	2	2			D3396-3	SPACER
56A	1	1	1	1			AN5C35A	BOLT
56B	1	1	1	1			AN5C13A	BOLT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3288-041 ASSEMBLY ABOVE
 (2) MAY BE REQUIRED ON -613/-614 INSTALLATIONS OR DART CROSSTUBES
 (3) NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS

5.0 WEIGHT AND BALANCE:

5.1 D206-642-111/-112/-211/-212/-311/-312/-411/-412 Skidtubes and Saddles

The following weight and balance information is for Dart D206-642-111/-112/-211/-212/-311/-312/-411/-412 skidtube and saddle installations only. The weight and balance of the skidtube and saddle installations that are being removed from the aircraft are the responsibility of the installer.

Note that the long wearshoe and ground handling kits are optional installations for flight. Weights for these (*) items should be subtracted if they are removed or otherwise not installed.

5.1.1 206 A/B Low Gear Skidtubes

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D206-642-111	17.4 lb	96.3 in	1676 in lb	-36.8 in	-640 in lb
206A/B LOW, LH	7.9 kg	2.44 m	19.3 m kg	-0.93 m	-7.3 m kg
D206-642-112	17.4 lb	96.3 in	1676 in lb	36.8 in	640 in lb
206A/B LOW, RH	7.9 kg	2.44 m	19.3 m kg	0.93 m	7.3 m kg
*D206-642-143	2.0 lb	96.3 in	193 in lb	+/- 36.8 in	+/- 74 in lb
WEARSHOE KIT	0.9 kg	2.44 m	2.2 m kg	+/- 0.93 m	+/- 0.8 m kg

5.1.2 206 A/B High Gear Skidtubes

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
206-642-211	18.6 lb	93.8 in	1745 in lb	-37.3 in	-694 in lb
206A/B HIGH, LH	8.4 kg	2.38 m	20.0 m kg	-0.95 m	-8.0 m kg
D206-642-212	18.6 lb	93.8 in	1745 in lb	37.3 in	694 in lb
206A/B HIGH, RH	8.4 kg	2.38 m	20.0 m kg	0.95 m	8.0 m kg
D206-642-213	18.6 lb	93.8 in	1745 in lb	-37.3 in	-694 in lb
206A/B HIGH, LH, THRU	8.4 kg	2.38 m	20.0 m kg	-0.95 m	-8.0 m kg
D206-642-214	18.6 lb	93.8 in	1745 in lb	37.3 in	694 in lb
206A/B HIGH, RH, THRU	8.4 kg	2.38 m	20.0 m kg	0.95 m	8.0 m kg
*D206-642-243	2.2 lb	93.8 in	206 in lb	+/- 37.3 in	+/- 82 in lb
WEARSHOE KIT	1.0 kg	2.38 m	2.4 m kg	+/- 0.95 m	+/- 1.0 m kg

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Revision: K

Date: 06.09.25

Date: Tuesday, 5/29/2007 9:57:20 AM
User: Kim Johnston

Process Sheet

Shuf June 14th

24

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE HIGH GEAR 206 A/B
Job Number : 32707A
Estimate Number : 10803
P.O. Number : N/A Part Number : D206642641
This Issue : 5/29/2007 S.O. No. : N/A Drawing Number : D3288 REV C
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : C
Previous Run : 32454A Material : N/A
Written By : Due Date : 6/15/2007 Qty: 1 Um: Each
Checked & Approved By : 07.05.29
Comment : Est Rev:B 05.11.15 Added washers for aft cap, wearshoes and ring EC
Est Rev:C 06-05-31 Revised steps JLM
Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-641 CHG002

N/A

2.0 D2620

Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 3" OD Bent Tube B3482

DP

7-5-31

3.0 D2647

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap B29328 BE 07-05-31

4.0 D32861

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler B29090

NP

7-5-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:57:20 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 32707A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube,grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288,Grind to obtain proper fit

AVR AL ROD

Batch: *BE 07-05-31*

4-Grind welds flush to cap on top surface onlly.

BE 07-05-31

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9-Insert D3286-1 doubler using DT8732 & DT8879 ,then locating doubler off the D3286-1 doubler ,leave Dt8732 for added support

3/16" holes cleco

10-Drill D3286-1 doubler rivet holes in tube using #40 drill,spot drilling doubler at the same time.

11-Working from center out,drill #30 holes into D3286-1 Doubler.cleco each hole after its drilled,Verify angle of holes to accomodate rivet heads.

12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.

13-Remove D3286-1 doubler,identify orientation,deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:57:20 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 32707A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 07-06-060

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

7-6-6

9.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

m16896

Pm 07-06-060

X

10.0

D3289041

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3289-041 Float Web

B24864

Pm 07-06-060

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Holes to finished size as per DWg D3288. Deburr.

Pm 07-06-060

2-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

Pm 07-06-060

3-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

m103861

Sikaflex expire-date:

07-10-01

Start: 07-06-06

Time: 1:30pm

Finish: 07-06-07

Time: 07:00am

(Adhere for 12 hours)

Pm 07-06-060

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP

7-6-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:57:20 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 32707A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

DP 7-6-7

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Debur

DP 7-6-7

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer

B21926 BE 07-06-11

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D3275-1 Crossbolt spacer

B21748 BE 07-06-11

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer

B29015 BE 07-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:57:20 AM

User: Kjm Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 32707A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

A/R Aluminum Rod *M102421 BE 07-06-11*

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

A/RSS Rod *B 29015 BE 07-06-11*

NONE

3-Grind welds flush to Fwd cap on top surface only.

BE 07-06-11

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

Pm 07-06-11

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

Pm 07-06-11

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 07-06-11

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-06-11

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M. L. 07/06/12

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR / M. L. 07-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:57:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 32707A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/06/12 ①

24.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3415-041 Nut Plate *B50837*

25.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CCR264SS3-3 Rivet *B19651*

26.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CR3212-4-03 Rivet *B15918*

27.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total: 64.0000 Each(s)

Insert

Batch: *m103495*

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288, Install with LPS-3

A/R LPS-3 Batch: *m104161*

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291 *m103561*

FL 07/06/13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:57:20 AM
User: Kjm Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 32707A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

Sikaflex expire date: 07/10

FD 07/06/13 ①

29.0

QC5

INSPECT WORK TO CURRENT STEP



2006-13 ①



Comment: INSPECT WORK TO CURRENT STEP
Inserts & Nut plate

30.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B31990

31.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B31991

32.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B31992

33.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B31993

34.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B31994

35.0

D353621

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
B31995

FD 07/06/13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:57:20 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 32707A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B31996

37.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B31996

38.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WEARPAD

Batch: B31725 (x2) B31937 (5x)

39.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B32071

40.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total : 66.0000 Each(s)

BOLT

Batch: m104291 (44x) m103641 (x22)

41.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 NAS1515H3L Washer m102535

42.0

AN960C10L

washer



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:57:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 32707A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

64 AN960C10L Washer m 102602

43.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3413-1 Ring B24869.

44.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN4C5A Bolt m 18918

45.0

~~AN960JD416~~

AN960C416

Washer



(PTO)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 ~~AN960JD416~~ Washer m 103338
AN960C416

46.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2646 Aft Cap B30119

47.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 AN960C10L Washer m 102602

FL 07/06/13 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/14	450	AN960C 416 washer required. Form change Change already made.					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/29/2007 9:57:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 32707A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

Sikaflex expire date:

m/03561
07/10

Feb 07/06/14
0

6-Coat all exposed fastners with LPS Procyon, remove any excess on powder coat with MEK Degreasser.

A/R LPS Procyon

Batch: m/04251

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jan 06-14
0

50.0

PACKAGING 1

PACKAGING RESOURCE #1



• Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location:

PPP Rev:

PPP 32707

P- 7/8/14
0

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/14
0

Job Completion



u 07-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3288	REV. C SHEET 1 OF 3
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.05.17	NEW ISSUE	
B	05.03.16	CHANGE INSERTS	
C	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED07.02.12 **[Signature]**

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2647	CAP
1	D2646	AFT CAP
9	D2649	CROSS BOLT SPACER
9	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
66	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
2	NAS1515H3L	WASHER

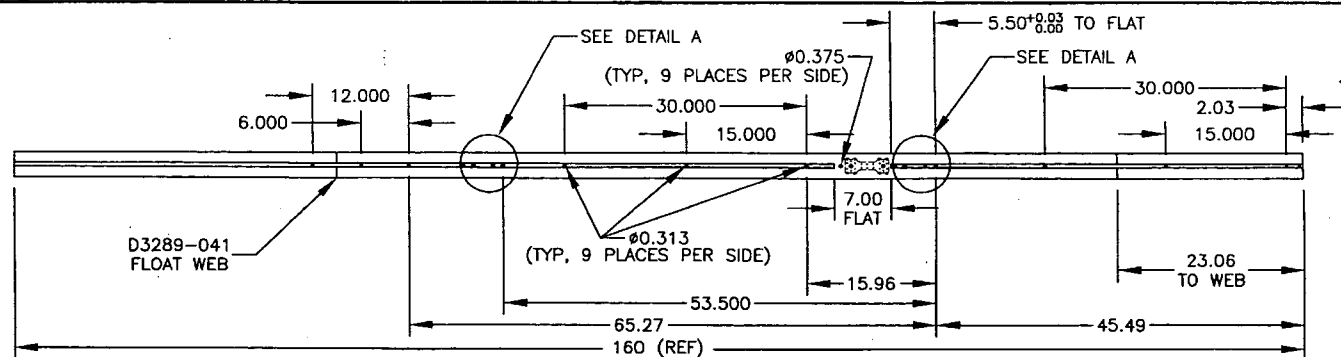
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/291. ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH:
 - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

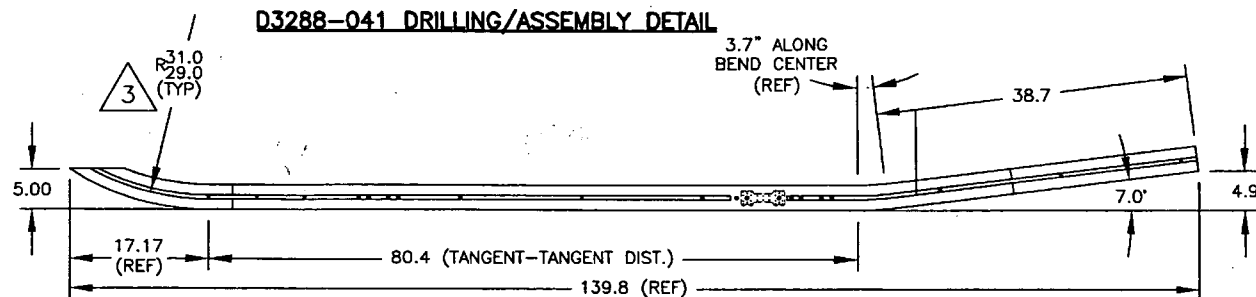
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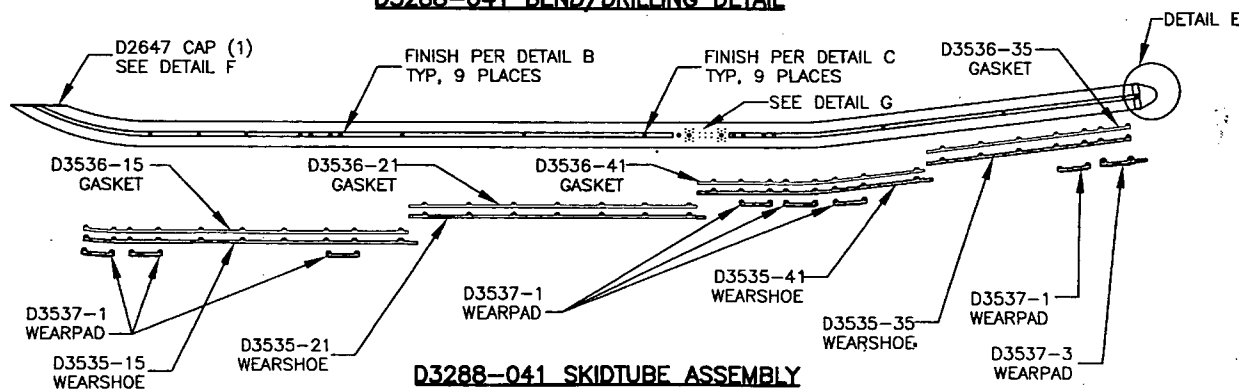
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D3288-041 DRILLING/ASSEMBLY DETAIL



D3288-041 BEND/DRILLING DETAIL



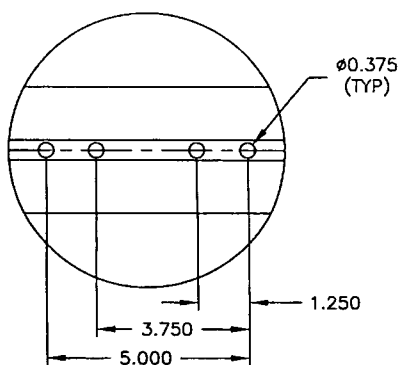
D3288-041 SKIDTUBE ASSEMBLY

RELEASED
07-02-12

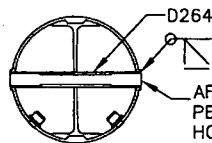
NO. 32701A
WORK ORDER
SUBJECT TO AMENDMENT
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CHECKED	DATE	APPROVED	DRAWING NO.	REV. C
#	06.12.19	#	D3288	SHEET 2 OF 3
TITLE			SKIDTUBE ASSEMBLY	SCALE
				1:15

DETAIL A: DRILL DETAIL

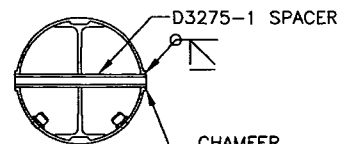


DETAIL B FOR 0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO 0.313x0.75 DEEP

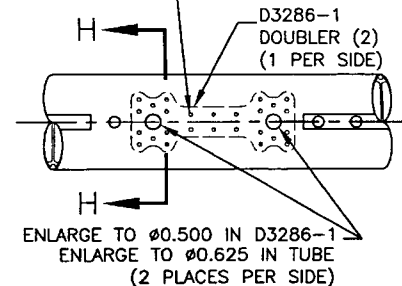
DETAIL C FOR 0.313 HOLES ONLY



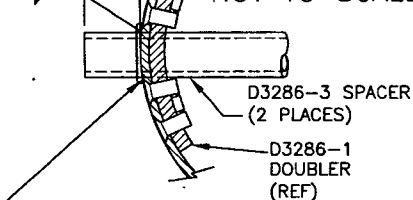
CHAMFER
0.030x45°
(TYP)

DETAIL G SCALE 1:5

DRILL #30
C'SINK 0.229x100°
INSTALL CR3212-4-04
RIVET (26 PER DOUBLER)

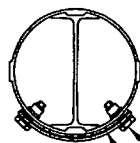


SECTION H-H NOT TO SCALE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO 0.500
 4. ENLARGE HOLES IN TUBE TO 0.625
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

DETAIL D



ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(64 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

RELEASED

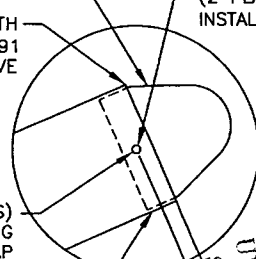
07.02.12

DETAIL E

AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP

SEAL WITH
SIKAFLEX-241/291
ADHESIVE



0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL

CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3
AN4C5A BOLT (1)
AN960C416 WASHER (1)
INSTALL WITH SIKAFLEX-241/-291
CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3
D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE,
LPS HARDCOAT ON EXTERIOR
D2647 CAP (REF)

D3413-1 RING

1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DESIGN
CP

DRAWN BY
PH

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

CHECKED
#

APPROVED
#

DRAWING NO.

D3288

REV. C

DATE
06.12.19

TITLE
SKIDTUBE ASSEMBLY

SHEET 3 OF 3

SCALE

1:3

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NO. 110

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number D206 642441 / B31983 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into NA Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/05/29 Qualifier David Dussel